

# Tapered burr Ø2.3 Z25 with radius

A11-011

The tapered burr Ø2.3mm is ground from a solid carbide blank. The requested geometry of all 25 teeth is achieved with a 1V1 wheel.



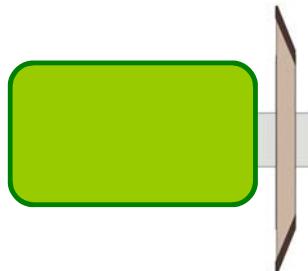
## 1. Cycletime for Production

Workpiece:			
Diameter 2.3 mm, Z 25, L14 mm, Helix angle 15°			
Material CARBIDE			
Operations	Probe	Flute 1	Flute 2
Feed [mm/Min]	2000	200	200
Power [kW]		3	2
Cutting speed [m/s]		32	32
Used wheels		1	1
Grinding time [s]	6	202	202
Total cycle time	6 Min 50		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

1	1V1 Ø60 D64
---	-------------



1
---

## 3. Machine and Software Requirements

Machines: 5 axes CNC grinder : Aries5

Control: Fanuc 31i

Accessories:

Responsible engineer: SIW, 05.13

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
Subsidiaries in: France, Deutschland, Italia, United States, China

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5